

Date: Thursday, 04/12/2008 10:35:04 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 05066	
Estimate Number : 13640	
P.O. Number :	Part Number : D37093
This Issue : 04/12/2008 S.O. No. :	Drawing Number : D3709 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : PRELIM
Previous Run : 43914	Material :
Written By :	Due Date : 11/12/2008 Qty: 3 Um: Each
Checked & Approved By : <u>umf 08-12-04</u>	
Comment : Est Rev:A 08-10-31 new issue DD verified by:EC	

Additional Product

PRELIMINARY ISSUE PROTOTYPE

Job Number:



509.0016 PER ECN#09-5028

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.2855 sf(s)/Unit Total : 0.8565 sf(s)

6061T6 aluminium sheet .063" thick

(M6061T6S063)

Batch: 108279

1B 9-1-13

1B 8-12-5

2.0	WATER JET	1	FLOW WATER JET
-----	-----------	---	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3709

Dwg Rev: PROTO

Prog Rev: TYPE

****grain direction on a 45 degree ****

2- Deburr if necessary

1B 9-1-13

1B 8-12-5

1B 8-12-5 1B 9-1-13

(5)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 8-12-5

1B 9-1-13

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

208-12-05 (5)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Form as per dwg D3709

FF 09/01/16 (1)

090114

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 05066

Part Number: D37093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



PTD last page

Comment: INSPECT WORK TO CURRENT STEP

09-01-16

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



FF 09/01/16

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ENGINEERING APPROVAL
09-01-16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-14
09/01/14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

D. Staw mf 09-06-08

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08

Job Completion



09-01-16
PROTOTYPE
POSITIVE RECALL
09-01-16

POSITIVE RECALL

EFFECTIVE 09/01/16 AUTH 11

RELEASED 09/06/05 DATE 09-06-05

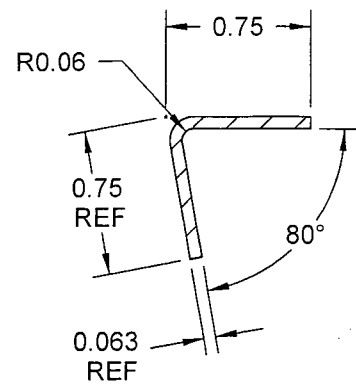
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3709-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/06/06
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

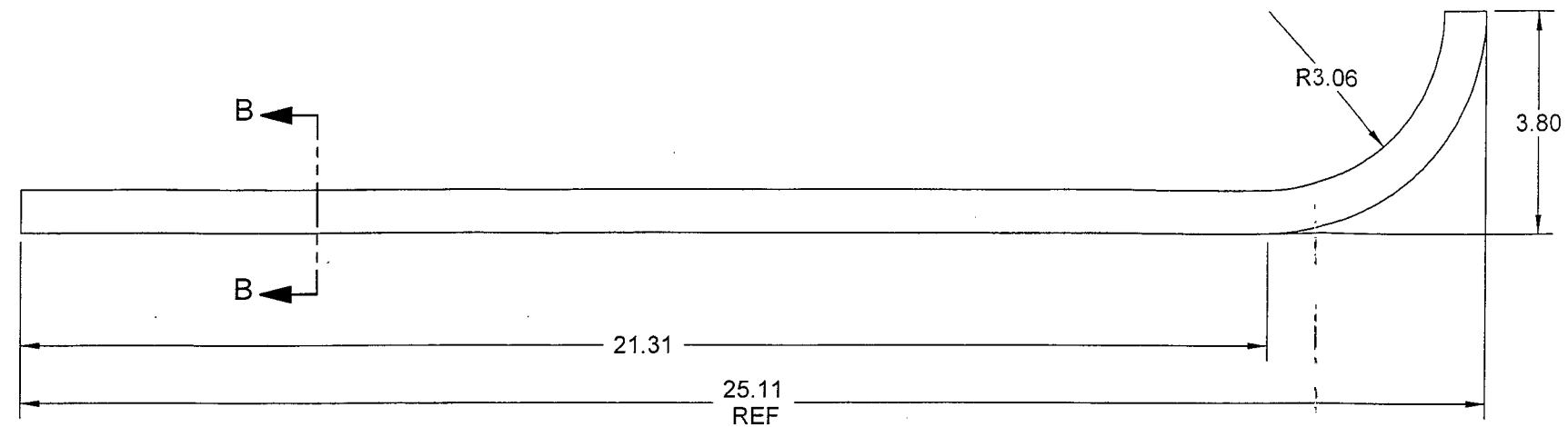
NCR: <u>05066</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/01/06</u>	<u>6</u>	<u>2 part were taking for right door prototype</u> <u>2 part crack at the bend</u>	<u>B</u> <u>09/01/06</u>	<u>Strip & destroy</u>	<u>FF</u> <u>09/01/06</u>	<u>B</u> <u>09.01.06</u>	<u>B</u> <u>09/01/06</u>	<u>B</u> <u>09/01/06</u>

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST



SECTION B-B
SCALE 2X

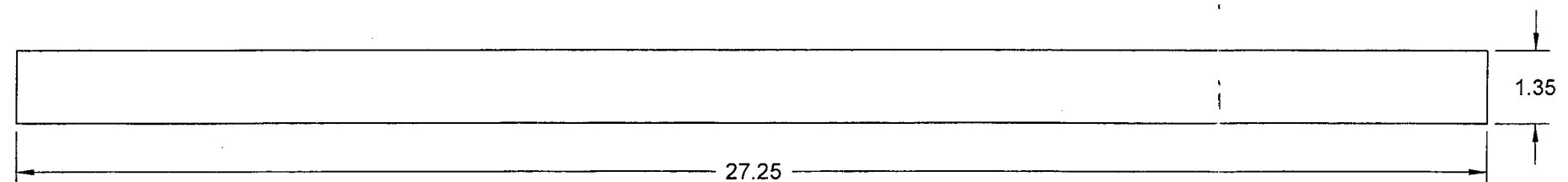


D3709-3 ANGLE
(MAKE FROM D3709-3F)

**PRELIMINARY
ISSUE**

08/10/31 MP

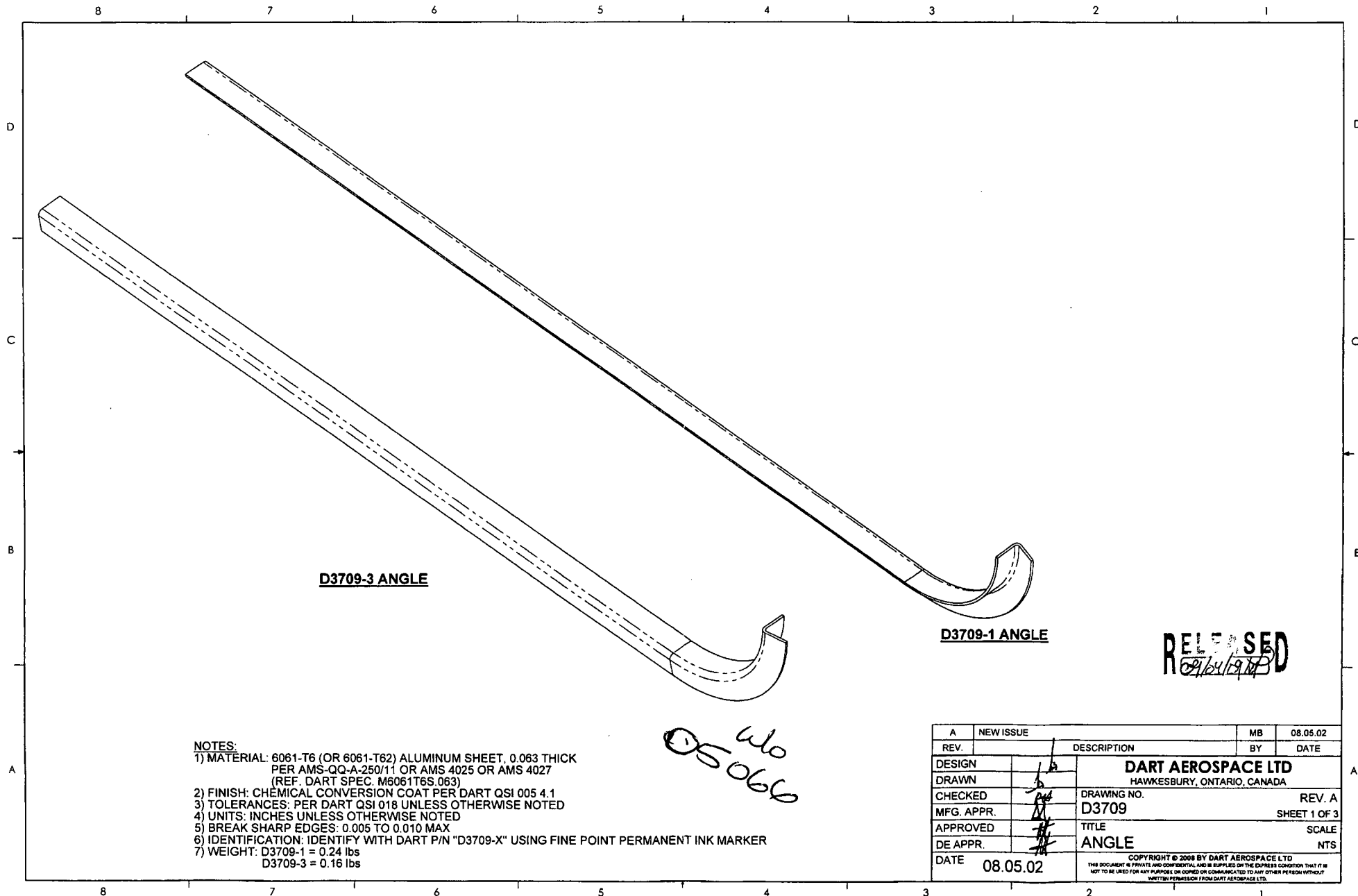
GRAIN
DIRECTION ↗

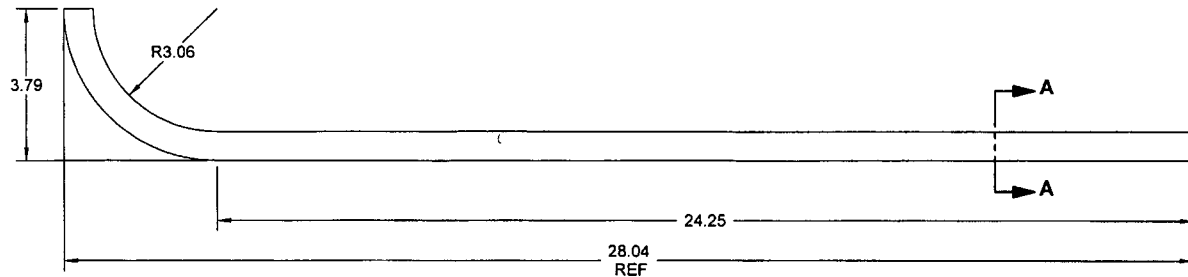


D3709-3F ANGLE FLAT PATTERN

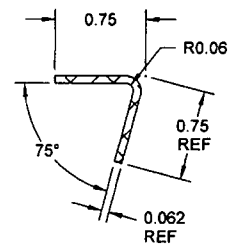
PROTOTYPE
09.01.16
PRELIMINARY ISSUE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3709	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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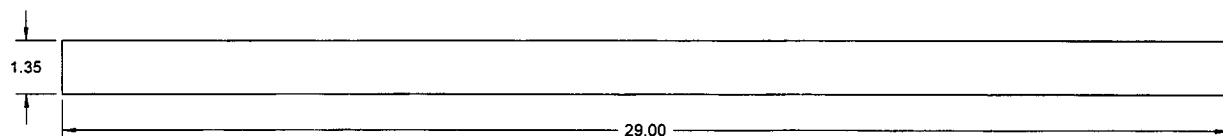




D3709-1 ANGLE
(MAKE FROM D3709-1F)



SECTION A-A
SCALE 2X

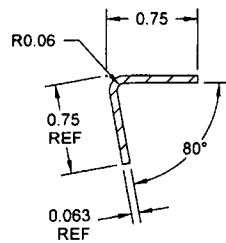


D3709-1F ANGLE FLAT PATTERN

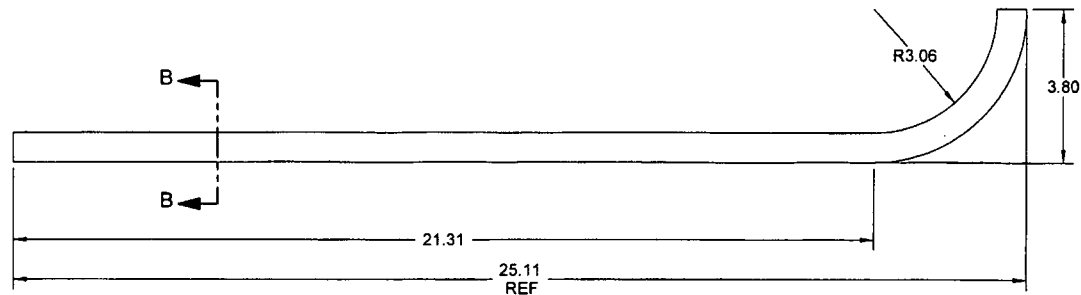
RELEASED
09/04/07

05066

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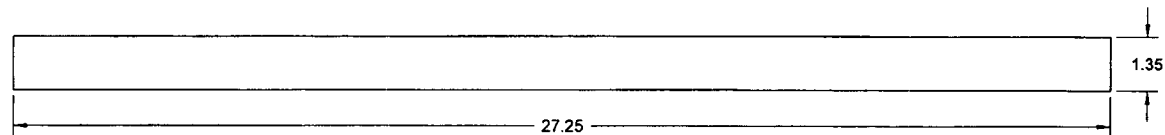


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

RELEASED
07/04/09

050666

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MFG. APPR.		D3709	SHEET 3 OF 3
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